



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

7154
RCCS

RBE117-68021W7
Job Sheet 185116



Part No: RBE117-68021W7

Job Qty: 4 ea

Part Name: Pusher



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/23/18

Job Tracking No:

Due Date: 11/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE117-68021W7 Rev. 1 IPP Rev. A 18.09.27 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	11/30/18	11/30/18	0.00	0.00	Start Up Machining-3		
120	CNC Lathe	4 pcs	11/30/18	11/30/18	0.00	4.00	MORI SL-154		
130	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC2 Machining-4		
140	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC8 Machining-4		
170	Outsource	4 pcs	11/30/18	11/30/18			GRO002-VC	10	
180	Packaging	4 pcs	11/30/18	11/30/18	0.00	0.00	Packaging2		
190	QC	4 pcs	11/30/18	11/30/18	0.00	0.00	QC6		
200	Packaging	4 pcs	11/30/18	11/30/18	0.00	0.00	Packaging3-1		
210	QC21-FG	4 Ea	11/30/18	11/30/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per DWG. FC423 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 170 - -Issue P/O to GROUPE ALTECH; PO 042833 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.750	AISI 4140 Quenched & Tempered Steel Round Bar 1.750" Dia.	.8520 ft (.213 ea)	90-Start up Operation	509412

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-4140QT-R1.750	1	16	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Id not be found.

Plex 10/23/18 7:44 AM Dart.lajeunesse.marie

Container No: S136669



Part: RBE117-68021W7

Job No: 185116

Serial No/Batch: S136669

Revision: 1

Inspector:

Exp Date:

Instructions:

Date: 12/11/18

QA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

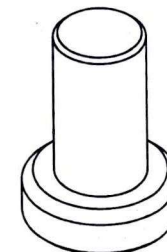
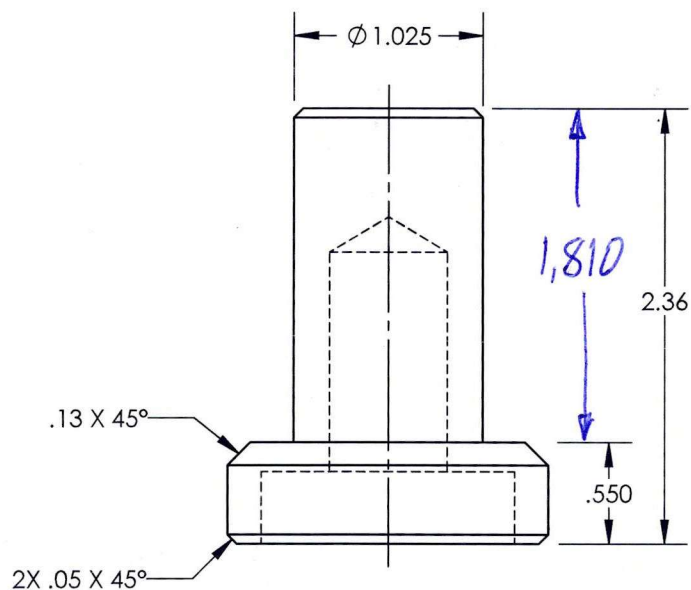
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

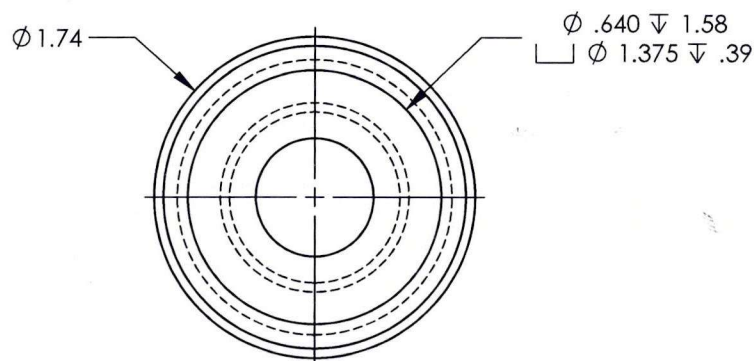
Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :			
Misidentified	☐	Past Due	☐				

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
1		RELEASED FOR PRODUCTION.		9/15/2016	SM	AG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185116 MJS
18-10-23



NOTES:
REF. AIRBUS T/N: 117-68021W7.

DART AEROSPACE	
TITLE PUSHER	
DWG NO. RBE117-68021W7	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT RC 28-34	.XXX ± .005 FRACTIONS ± 1/8
TREAT	.XX ± .01 ANGLES ± 5°
FINISH BLACK OXIDE	.X ± .1 SURFACES = 125/
SPEC QMSI-6.2.2, B.O. REV D	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	H145
APPROVED: GILBERT	
SCALE 1:1	DATE 7/21/2016
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				1	PUSHER	4140/4142		1

13 3/4 left (12 1/4 used)

Q, 16883 Extra (Scrap)



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042033**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042033
PO Date: 12/12/18
Due Date: 12/19/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185116	RBE117-68021W7	Pusher -Issue P/O to GROUPE ALTECH; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	12/19/18	4 pcs	0 pcs	4 pcs	\$3.4285714/pcs	\$13.71
2	181157	RBE350A94-3700-A-01	Tube -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	12/19/18	31 pcs	0 pcs	31 pcs	\$3.4285714/pcs	\$106.29
Grand Total:											\$120.00



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PURCHASE ORDER PO042033

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 12/12/18 2:27 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(015344-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

015344 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
21-Dec-2018		Aman		042033				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE117-68021W7 Rev.	RBE117-68021W7 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS1 APPLY A THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
2	RBE350A94-3700-A-01 Rev.	RBE350A94-3700-A-01 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	31	31	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

[Signature]

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.